



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2647

Job Sheet 171428



①

Part No: D2647

Job Qty: 30 ea

Part Name: Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/12/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV F IPP Rev:D 99.01.25 Re-format DM IPP: E 06.11.15 waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		2/10/18	0.00	0.00	Start Up Waterjet		Sc 18/02/04
100	Waterjet	30 pcs		2/12/18	0.02	0.71	Waterjet1		Sc 18/02/04
120	QC	30 pcs		2/12/18	0.00	0.00	QC8		Sc 18/02/04
150	Packaging	30 pcs		2/12/18	0.00	0.00	Packaging3		Sc 18/02/04
160	QC21-SA	30 Ea		2/12/18	0.00	0.00	QC21		Sc 18/02/04

Part Op 100 - 1-Cut as per Dwg D2647 Dwg Rev: F Prog Rev: F 2-Deburr if necessary
Descriptions: 150 - ***STOCK IN SKIDTUBE CELL*** LOCATION : LG001

DAG
21
9-00
FEB 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	4.7910 sf (.1597 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	5	204	0

5.5

DART
AEROSPACE
S038805

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Cap

PART NO: D2647
Original Serial #: S038805
Revision:
Operation: Start up Operation
Change No:

02/04/18
Job No: 171428

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	0.098inches	+ 0.004 - 0.001	0.102 0.097	
2	Cap	0.129inches	+ 0.005 - 0.001	0.134 0.128	
3	Cap	0.420inches	± 0.010	0.430 0.410	
4	Cap	0.810inches	± 0.010	0.820 0.800	
5	Cap	0.350inches	± 0.010	0.360 0.340	
6	Cap	0.720inches	± 0.010	0.730 0.710	
7	Cap	0.370inches	± 0.010	0.380 0.360	
8	Cap	2.900inches	± 0.030	2.930 2.870	
9	Cap	6.850inches	± 0.030	6.880 6.820	

Plex 2/1/18 9:38 AM Dart.Gagnon.Michelle

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	171428
Description: Cap		Part Number:	D2647
Inspection Dwg: D2647		Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0.099	1		VIZ-02	
Ø0.129	+0.005/-0.001	Ø0.129	1			
0.420	+/-0.010	0.422	1			
0.810	+/-0.010	0.811	1			
0.350	+/-0.010	0.353	1			
0.720	+/-0.010	0.722	1			
0.370	+/-0.010	0.371	1			
2.90	+/-0.030	2.905	1			
6.85	+/-0.030	6.846	1			

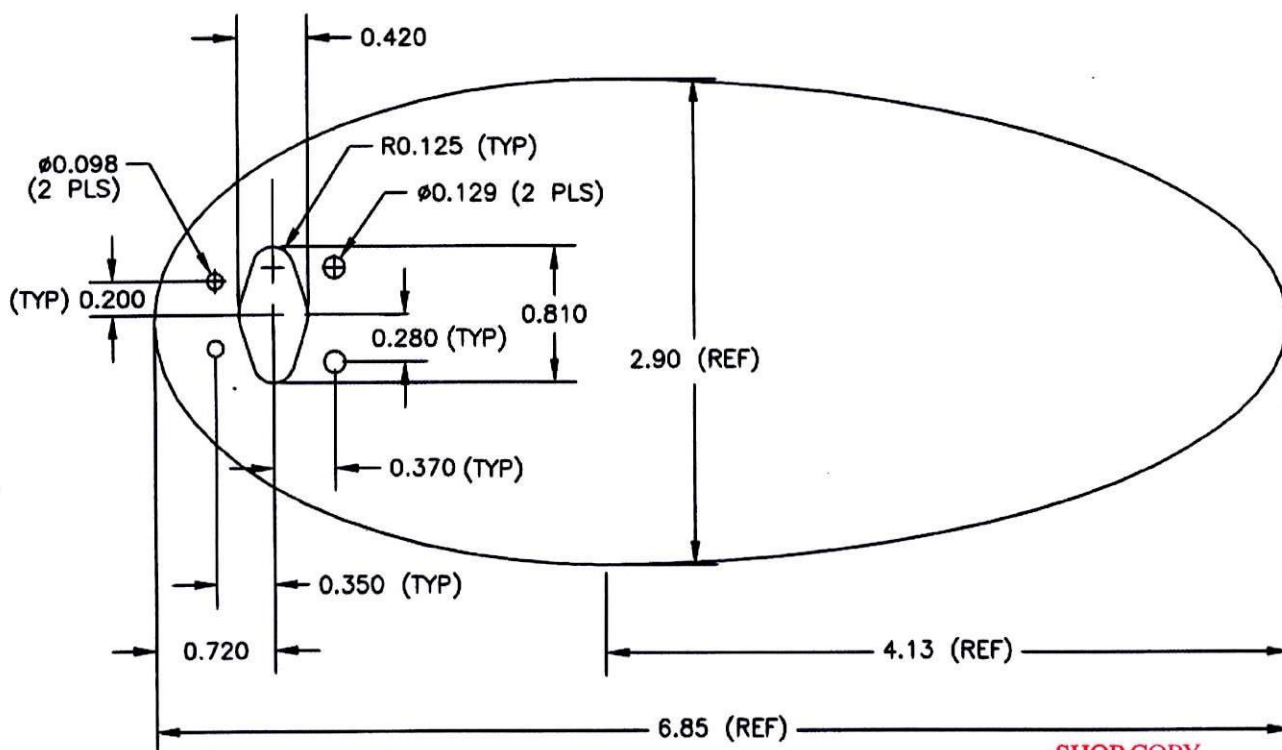
Measured by:	JC	Audited by:	ERB	Prototype Approval:	N/A
Date:	18/02/04	Date:	FEB 05 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.26	New Issue	KJ/EC/DD	
B	09.03.10	0.370 dimension removed	KJ/DD	



DESIGN #	DRAWN BY RT	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2647	REV. F SHEET 1 OF 1
DATE 00.05.26		TITLE CAP	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.27	CHANGED SHAPE	
C	97.09.15	REMOVE FRONT PLATE	
D	97.11.06	ADD RIVET HOLES	
E	98.01.15	ADD 5052 MATERIAL (TSR A245)	
F	00.05.26	MAKE FROM D2794	

RELEASED
00.06.09



THIS PART CAN BE MADE FROM D2794

MATERIAL: 6061-T6 (QQ-A-250/11) OR
5052-H32 (QQ-A-250/8) 0.080 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 171428
FEB 01 2018

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